

Work Order ID 62161

PRELIMINARY ISSUE

Monday, September 20, 2010 8:28:21 AM

Page 1

Item ID: D4132-3

Accept



Setup Start



Revision ID:

Item Name: Gasket

Stop



Start Date: 9/20/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 9/27/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10/9/2010 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D4132	pb1

100



FLOW WATER JET

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D4132
 Dwg Rev: pb1
 Prog Rev: pb1
 2-Deburr if necessary

0.00

SCRAP per Chg 8/21

B10-9-21

(4)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

Memo

0.00

B10-9-21

120



QC8- Inspect parts - second check

0.00 - inspect to PB1

QC

Quality Control

Memo

0.00

*Dry only
8/10/2010 (4)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62161

Monday, September 20, 2010 8:28:21 AM



Page 2

Item ID: D4132-3

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Cust Item ID:

Required Date: 9/27/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location:

0.00



Packaging

Packaging

Memo

0.00

PB 10-09-29 ④

140

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

H 2009.89 11

POSITIVE RECALL

EFFECTIVE 09.29 AUTH W

RELEASED _____ DATE _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Monday, September 20, 2010 8:28:26 AM

Work Order ID: 62161



Parent Item: D4132-3



Parent Item Name: Gasket

Start Date: 9/20/2010

Required Date: 9/27/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	477.6133	1.0446	4.398316		LB 10-9-21	

NEOPRENE SHEET 0.063



Location	Loc Qty	Loc Code
MAT	372.3602	
114691	105.9602	
115500	266.4	
MAT052	105.2531	
114176	105.2531	

115500

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 62161
Description: GASKET	Part Number: D4132-3
Inspection Dwg. D4132-3 Rev: pb1	Page 1 of 1

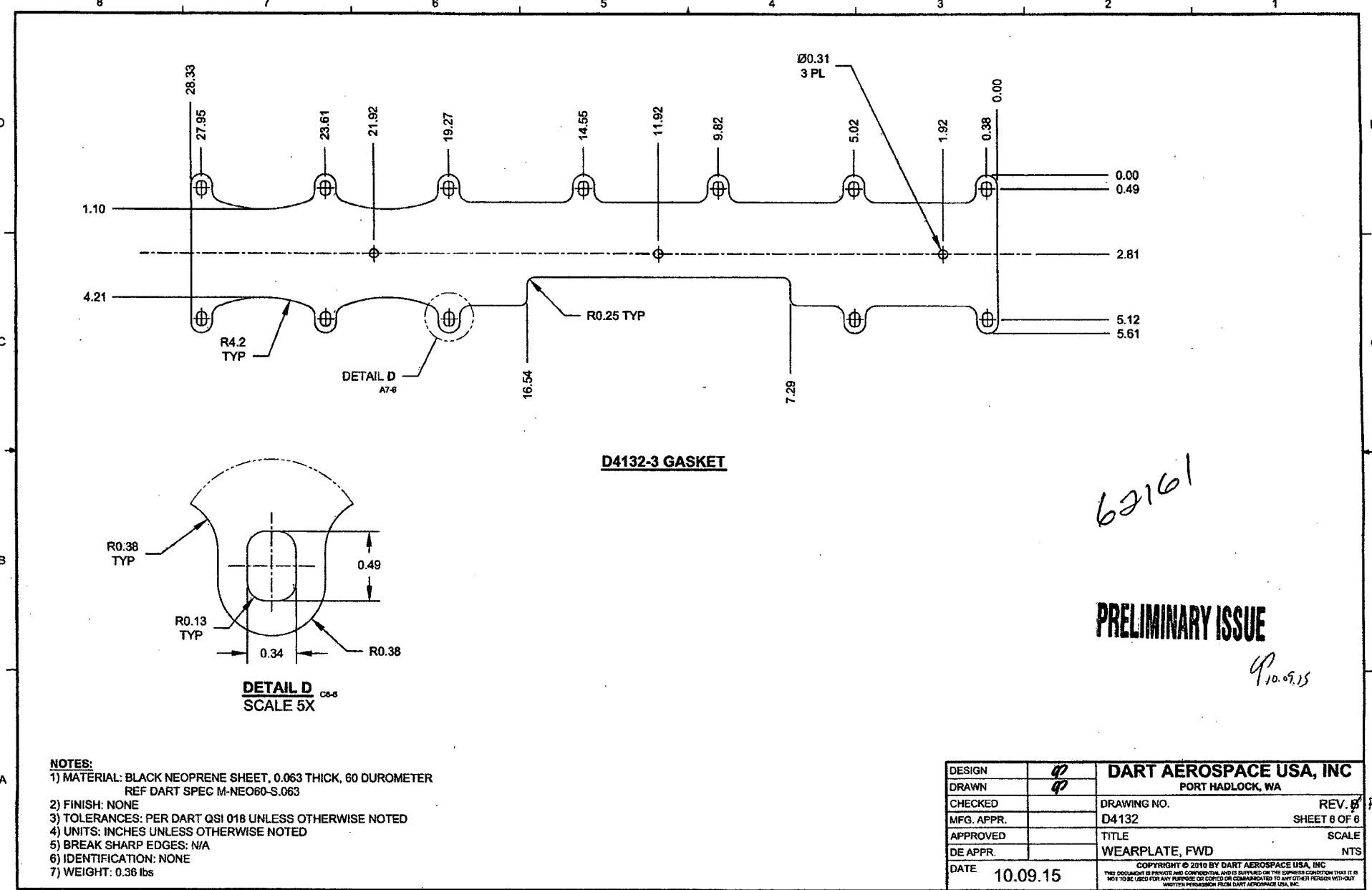
FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.31	.006 - .001	.314	✗		VBOD	
.49	.030	.488	✗		✓	
2.81	.020	2.797	✗		✓	
5.12	.030	5.118	✗		✓	
5.61	.030	5.605	✗		✓	
.49	.030	.478	✗		✓	
.34	.020	.339	✗		✓	
1.10	.030	1.130	✗		✓	
4.21	.030	4.240	✗		✓	
.38	.020	.382	✗		✓	
1.92	.030	1.919	✗		✓	
5.02	.030	5.018	✗		✓	
9.82	.030	9.818	✗		UPRO VBOD	
11.92	.030	11.908	✗		"	
14.55	.030	14.55	✗		T	
7.29	.030	7.298	✗		✓	
16.54	.030	16.50	✗		T	
19.27	.030	19.250	✗		T	
21.92	.030	21.93	✗		T	
23.61	.030	23.61	✗		T	
27.95	.030	27.95	✗		T	
28.33	.030	28.33	✗		T	
.663	.010	.663	✗		✓	

Measured by: RS	Audited by: S	Prototype Approval: N/A
Date: 10-9-21	Date: 10/09/22	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 0.063 THICK, 60 DUROMETER
REF DART SPEC M-NEO60-S.063
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 01B UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.36 lbs

DESIGN	99	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	99		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4132	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE, FWD	NTS
DATE	10.09.15	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PROPRIETARY INFORMATION OF DART AEROSPACE USA, INC. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	